

Date: Thursday, 18/12/2008 12:51:07 PM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	WEARSHOE		
Job Number	44159			Part Number	D265637		
Estimate Number	10618			Drawing Number	D2656 REV D		
P.O. Number	:			Project Number	N/A		
This Issue	18/12/2008 S.O. No. :			Drawing Revision	D		
Prsh Rev.	NC			Material	:		
First Issue	18/12/2008 Type : SMALL /MED FAB			Due Date	10/01/2009 Qty: 10 Um: Each		
Previous Run	43285						
Written By	:						
Checked & Approved By	JUL 08. Q. 19						
Comment	Est Rev: D 02.10.25 Re-format KJ Est Rev: E 06-06-12 Now on Waterjet JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S20GA	1010/1025 SHEET
		Comment: Qty.: 0.5650 sf(s)/Unit Total : 5.6501 sf(s) 1010/1025 .040" SHEET (M1010S20GA) Batch: <u>110368</u> HB 9-1-8
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2656 Dwg Rev: <u>D</u> Prog Rev: <u>D</u> HB 9-1-8
		2-Deburr if necessary HB 9-1-8
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		HB 9-1-8
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		S 09/01/08 (4/3)
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		a/18
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

Date: Thursday, 18/12/2008 12:51:08 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 44159

Part Number: D265637

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326.

2- Identify as D2656-37

SB 09/01/12 (13)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/12 +13

8.0 POWDER COATING POWDER COATING



m109648

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

(13)

START TIME: 6:40

OVEN TEMPERATURE: 320°

FINISH TIME: 7:10

Fx 09/01/13

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



MJ

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-13 (13)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-20

Fx 09/01/14 (13)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



09/01/15 MJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JW 09/01/14 (13)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	L44159
Description: Wearshoe	Part Number:	D2656-37
Inspection Dwg: D2656 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

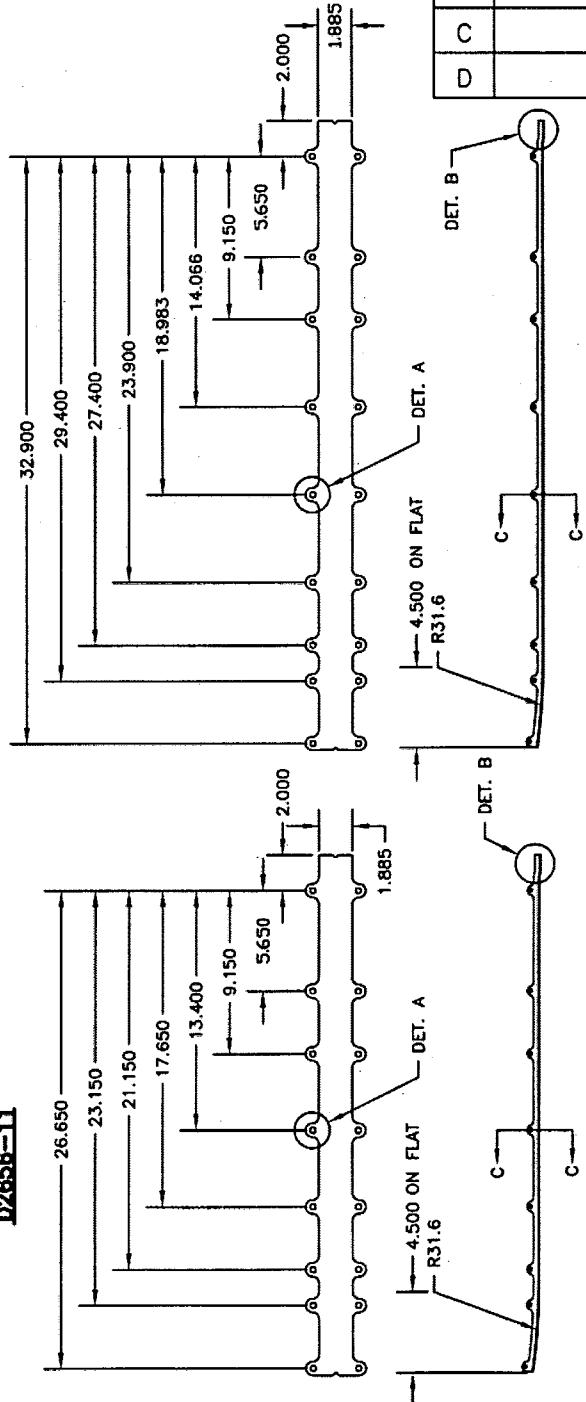
Measured by:	<u>B</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	9-1-8	Date:	08/01/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	
B	08.11.27	Dimensions updated per Dwg Rev. D	KJ/EC	

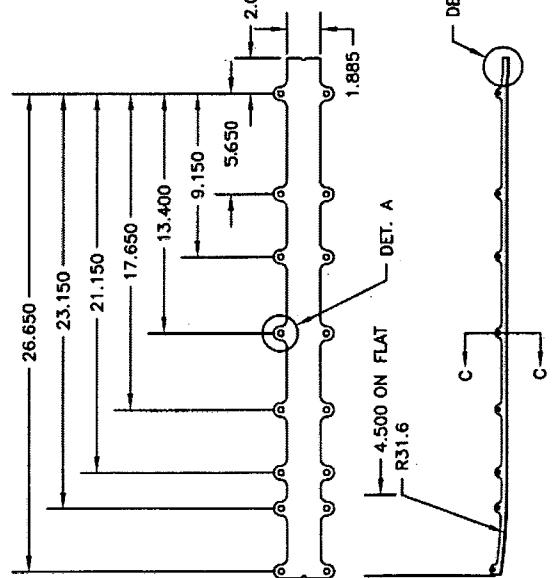
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DS	CP	
CHECKED	APPROVED	DRAWING NO. REV. D D2656 SHEET 1 OF 4
DATE		TITLE SCALE
05.08.17		WEARSHOE 1:10

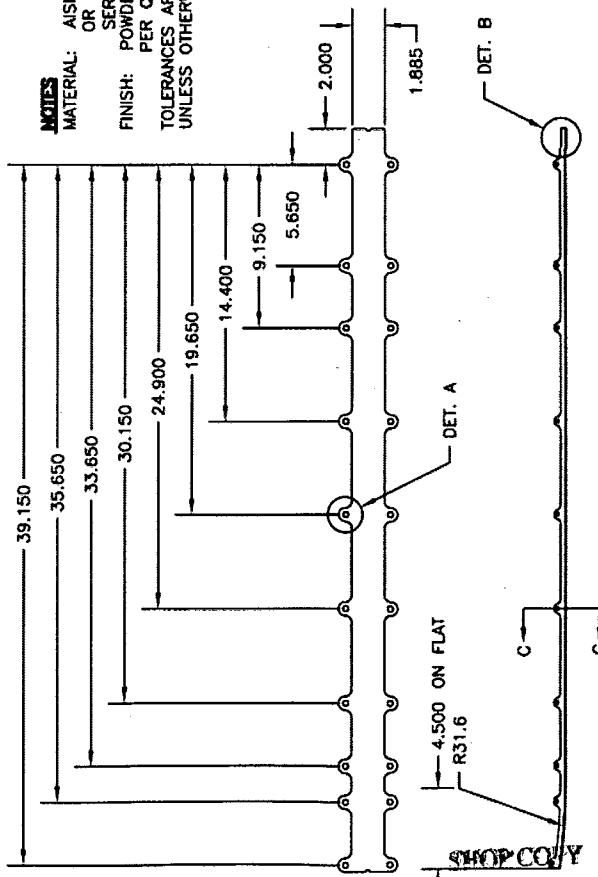
D2656-13



D2656-11



D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08

SUBJECT TO AMENDMENT
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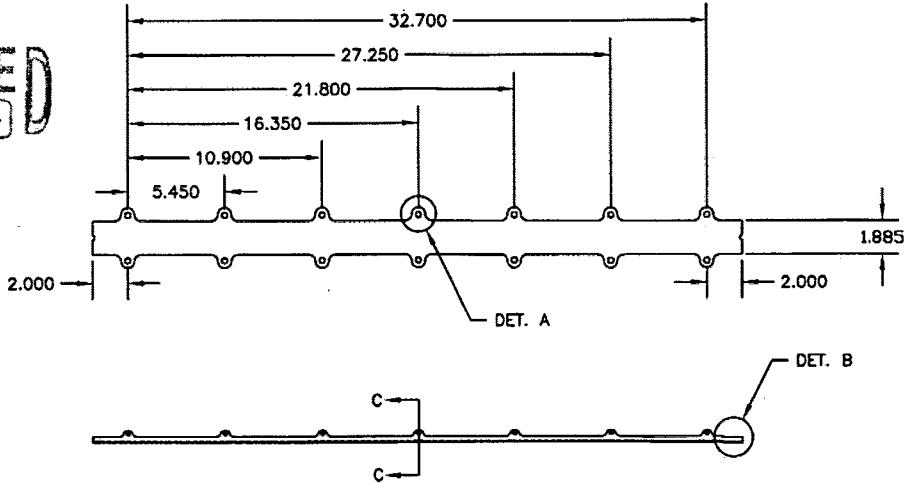
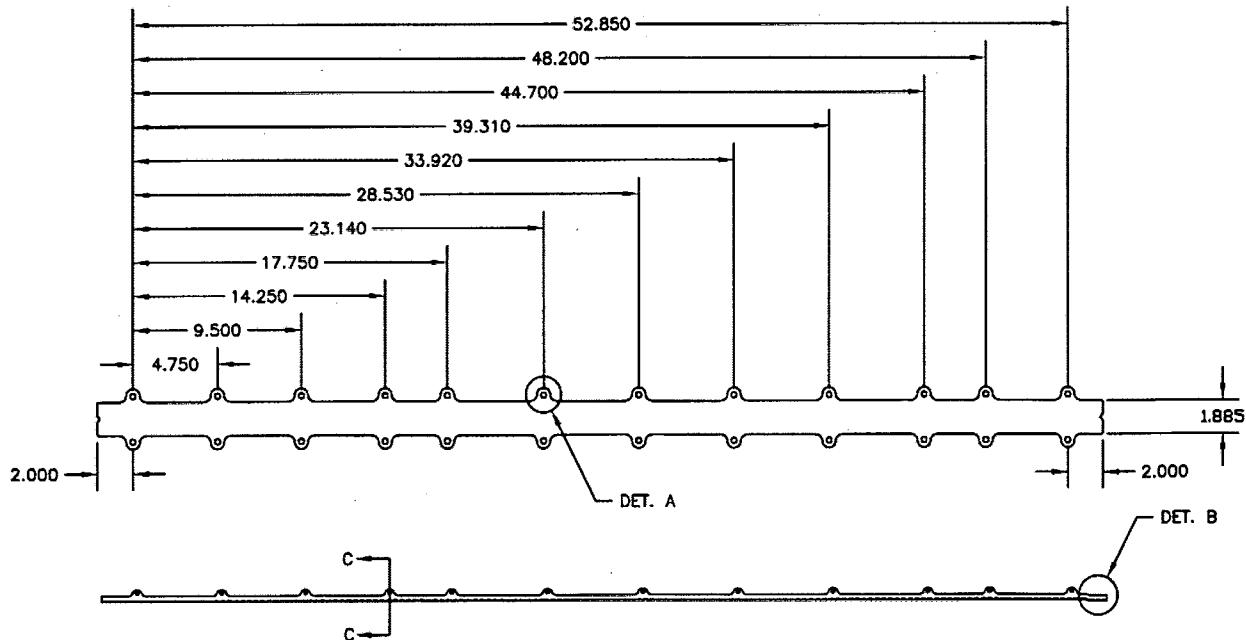
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WORK ORDER
NO. 124415

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		REV. D SHEET 2 OF 4

05.08.17

TITLE
WEARSHOESCALE
1:10D2656-21**RELEASED**
05.01.06D2656-23**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)

FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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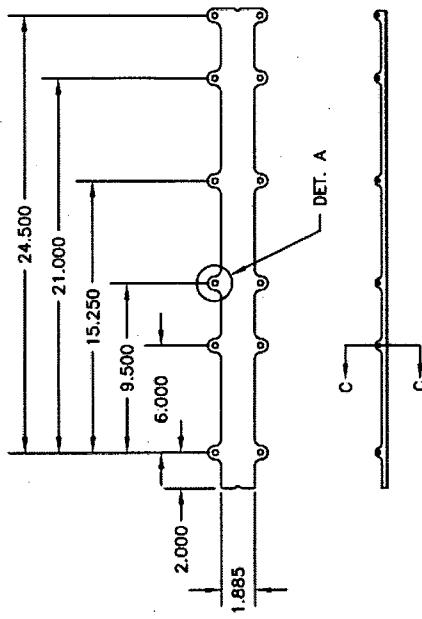
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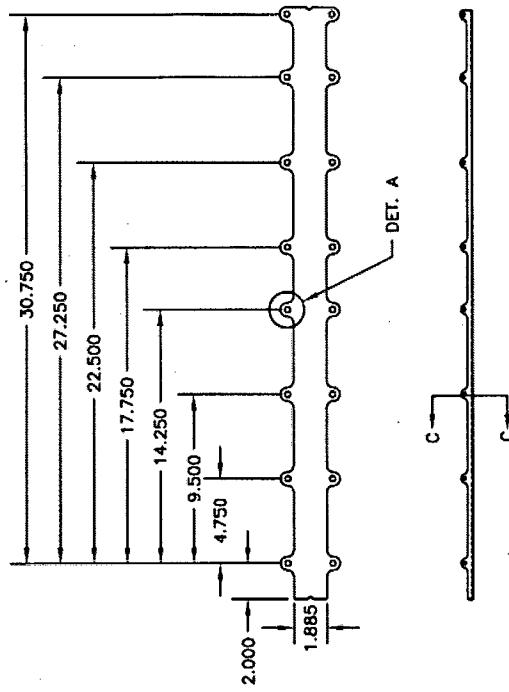
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DS	CP	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D2656
DATE	TITLE	REV. D
05.08.17	WEARSHOE	SHEET 3 OF 4
		SCALE
		1:10

D2656-33

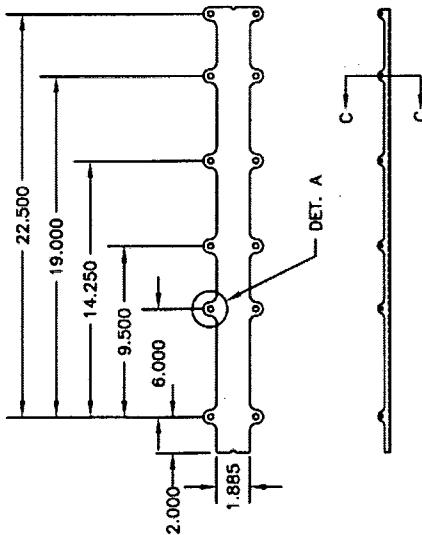


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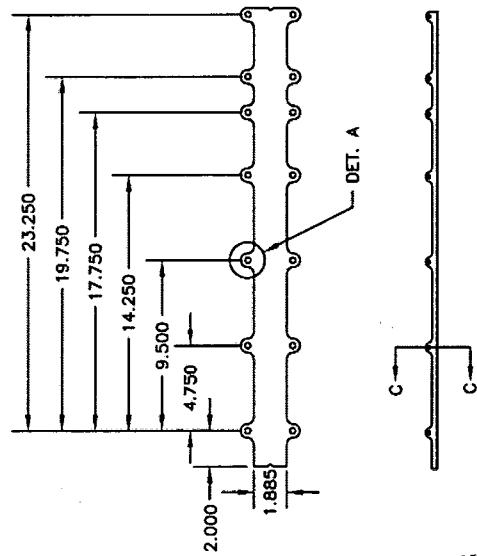


RELEASED
05.07.06

D2656-31



D2656-35



NOTES
SHOP MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21, 38W/44W/50W/60W/70W
FINISH: SERIES STEEL, 20 GAUGE (0.040 THICK)
TOLERANCES ARE PER DART QSI 005 4.3
UNLESS OTHERWISE NOTED

WORK ORDER
NO. 4455

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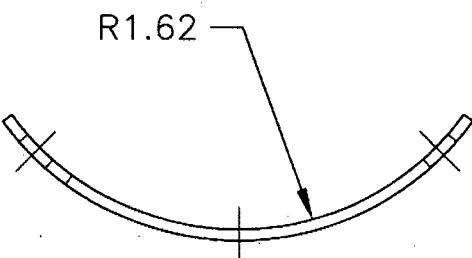
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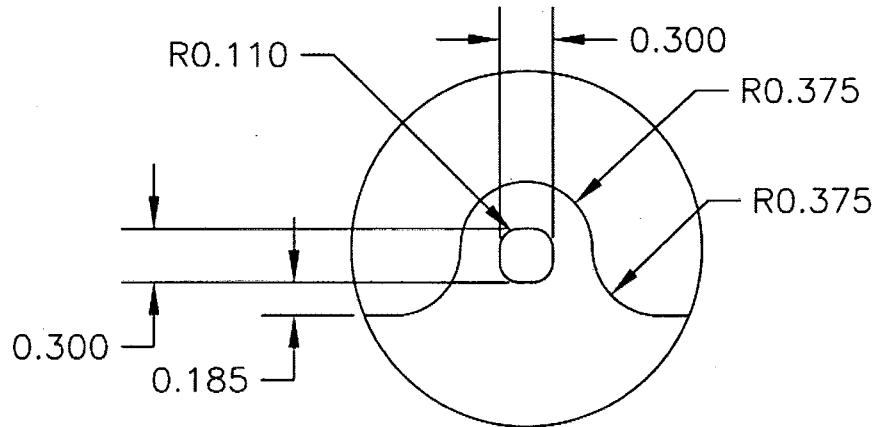
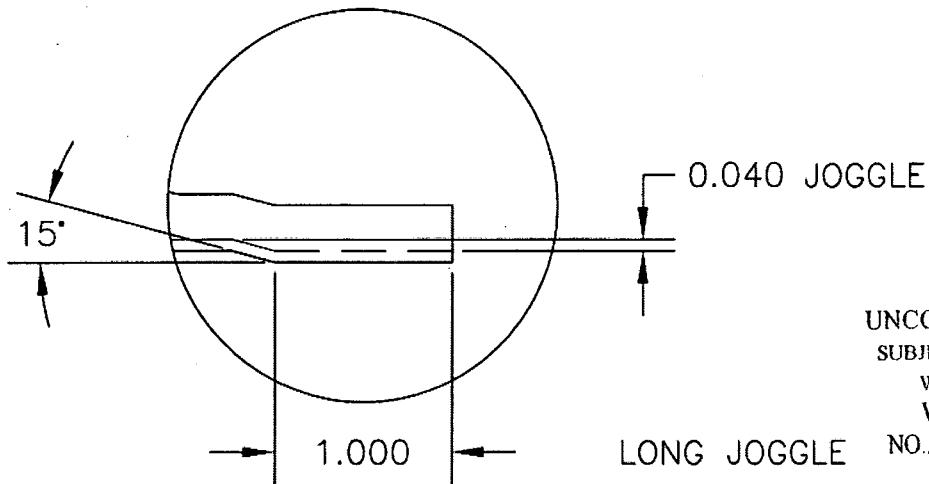
WORK ORDER
NO. 4455

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 4 OF 4
DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

RELEASED
05.09.06 #5

DETAIL ADETAIL B

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